

Work Order ID 142950

Monday, March 14, 2016 11:04:46 AM

142950

Page 1

Item ID: D205-633-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH
 Start Date: 3/15/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/18/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MCJ Date: **MAR 14 2016** Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D205-633	C			DAS 6				MCJ	16-03-14

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP205-633-011 CHG001

Handwritten: X.Y, DAS 27 9-89, 16-03-14, (4)

MAR 15 2016
 MAR 15 2016

110 Pick Kit 0.00

110
 Packaging Memo 0.00
 Packaging

Handwritten: 4, MAR 14 2016, DAS 6 9-89

DAS 28 9-89

120 QC4- 100% Inspect kits for completeness 0.00

120
 QC Memo 0.00
 Quality Control

Handwritten: X.Y, DAS 27 9-89

MAR 15 2016
 MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 142950***142950***

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Page 2

Item ID: D205-633-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 3/18/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					4	DAS 27 9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>FG082</u>								
									MAR 15 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MAR 15 2016
Quality Control									

MCS MAR 15 2016

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Monday, March 14, 2016 11:04:49 AM

Page 1

Work Order ID: 142950

142950

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016

Required Date: 3/18/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No			110	Each	563.0000	1	27			
**													
												DAS	DAS
												6	28
												9-89	9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 2

Work Order ID: 142950

142950

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016

Required Date: 3/18/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-6A

Purchased

No

110

Each

884.0000

2

48

DAS

6

9-89

DAS

28

9-89

AN4-6A

BOLT

**

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST345

741

M133363

1

M133790

740

DAS

27

9-89

AN4-7A

Purchased

No

110

Each

101.0000

2

48

DAS

6

9-89

DAS

28

9-89

AN4-7A

Bolt

**

Location

Loc Qty

Loc Code

ST325

1

m133790

1

ST345

100

m134249

100

DAS

27

9-89

AN5-14A

Purchased

No

110

Each

32.0000

1

24

DAS DAS

6

9-89 9-89

28

AN5-14A

Bolt

**

Location

Loc Qty

Loc Code

ST338

32

m133990

32

DAS

27

9-89

AN5-6A

Purchased

No

110

Each

41.0000

1

24

DAS

28

9-89

DAS

28

AN5-6A

Bolt

**

Location

Loc Qty

Loc Code

ST339

41

m133790

41

DAS

27

9-89

MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Page 3

Monday, March 14, 2016 11:04:49 AM

Work Order ID: 142950

142950

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016

Required Date: 3/18/2016

Start Qty: 2.00

Required Qty: 2.00

D2021-101
D2021-101
Eyebolt

Manufactured No

110 Each

10.0000

1 24
**

DAS 6 9-89
DAS 28 9-89

Location

Loc Qty

Loc Code

ST001

10

130984

1

141035

9

D2022-101
D2022-101
Spacer

Manufactured No

110 Each

113.0000

2 48
**

DAS 6 9-89
DAS 28 9-89

Location

Loc Qty

Loc Code

ST001

67

132703

67

ST012a

46

140201

46

D2022-103
D2022-103
Spacer

Manufactured No

110 Each

18.0000

2 48
**

DAS 6 9-89
DAS 28 9-89

Location

Loc Qty

Loc Code

ST001

18

139455

18

D2562-00139
D2562-001
Strut 19.68"

Manufactured No

110 Each

7.0000

1 24
**

DAS 6 9-89
DAS 28 9-89

Location

Loc Qty

Loc Code

ST353

7

142445

7

D2563
D2563
Step Weldment Assembly

Manufactured No

110 Each

0.0000

1 24
**

DAS 6 9-89
DAS 28 9-89
DAS 6 MAR 14 2016
DAS 28 9-89

B142121 X4

Monday, March 14, 2016 11:04:49 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition					
								Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Page 5

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016

Required Date: 3/18/2016

Start Qty: 2.00

Required Qty: 2.00

D2565-111

Manufactured No

110

Each

6.0000

D2565-111

Strut

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST354

6

141051

6

110

Each

1,755.000

**

DAS
27

MS21042L4

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

447

m133769

447

ST303

1174

m134055

1174

ST305

97

m130922

97

110

Each

445.0000

**

DAS

6

9-89

DAS

28

9-89

DAS
27

9-89

MS21042L5

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST303

299

m134055

299

110

Each

445.0000

**

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

MAR 14 2016

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Shop Packet Print

Page 5

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Page 6

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/15/2016

Required Date: 3/18/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

3,551.000

15

30.60

NAS1149D0463.J

WASHER

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	237
M129390	41
M132035	196
ST263	2326
M134039	2326
ST269	988
M132317	100
M132677	888

DAS

6

9-89

DAS

28

9-89

60

NAS1149D0563J

Purchased

No

110

Each

1,045.000

4

8.16

NAS1149D0563.J

Washer

**

Location

Loc Qty

Loc Code

GA	307
m125807	12
m133769	295
ST263	635
m133990	135
m134257	500
ST269	103
m128257	103

DAS

6

9-89

DAS

28

9-89

MAR 14 2016

16

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : ☐																							

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
1		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563-1	WELDMENT-ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
1	1	1		AN4-10A	BOLT
			1	AN5-6A	BOLT
	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13